

Work Order ID 86324

Wednesday, June 27, 2012 10:54:13 AM

Push Now
86324

Page 1

Item ID: D4422-3

Accept

No W
N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Shim

Start Date: 6/27/2012 Start Qty: 2.00

2

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals:

Process Plan: *mk*Date: *12-06-27* Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4422

A

100

0.00

100

Small Fab

Small Fab

Memo

Shear as per dwg D4422

0.00

*2**0**FF 12-06-27*

110

QC6- Inspect dimensions to drawing

0.00

110

QC

Quality Control

Memo

0.00

*2**SA 12-06-27**115-**PTO*

120

Identify as per dwg & Stock Location:

0.00

120

Packaging

Packaging

Memo

0.00

12-06-27

W/O: 86324

Rem CAG

WORK ORDER CHANGES

DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector
12-06-27	115	Needs to add. a/c time. update ROUTING.	JS	12677		h	

Part No: D4422-3 PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 86324

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Item ID: D4422-3

Accept

N900040100

Setup Start ***NS1***

Revision ID:

Item Name: Shim

Stop ***NS2***

Start Date: 6/27/2012 Start Qty: 2.00 ***2***

Cust Item ID:

Required Date: 6/27/2012 Req'd Qty: 2.00 ***2***

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____

Tooling:

Date:

Run Start ***NR1***

QC: _____ Date: _____

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

130

QC21- Final Inspection - Work Order Release

0.00

130

QC

Memo

0.00

Quality Control

12/6/28
WVG
12-06-27

Picklist Print

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Page 1

Work Order ID: 86324

Parent Item: D4422-3

Parent Item Name: Shim

Start Date: 6/27/2012

Required Date: 6/27/2012

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP revA 11.06.30 new issue EC verified by:JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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M6061T6S.063

Purchased

No

sf

514.0868

0.0488632

6061-T6 .063 Sheet

Location

Loc Qty

Loc Code

MAT021

514.0868320

113608

0

116308

5.01556842

117285

67.544

119331

44.2

119802

5.94

120218

17.31

120866

64.8126316

121805

309.264632

0.0488632

② 88-12-06-27

8 7 6 5 4 3 2 1

D

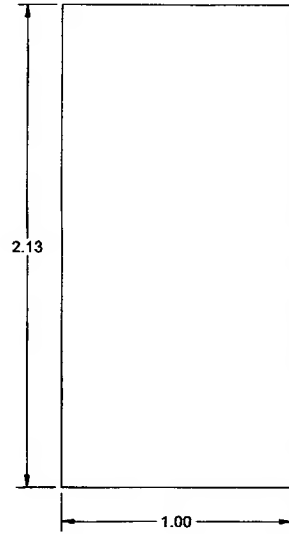
C

B

D

C

B



D4422-X SHIM



P/N	"T" THICKNESS
D4422-1	0.125
D4422-3	0.063

NOTES:

1) MATERIAL:

- D4422-1: 6061-T6/T62 ALUMINUM SHEET, 0.125 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.125
OR
6061-T6/T651/T6510/T6511/T62, 0.125 X 1.000, PER QQ-A-225/8
OR AMS-QQ-225/8 (OR AMS 4117/4128/4115/4116) OR QQ-A-200/8 (OR AMS 4160)
OR ASTM B211 OR ASTM B221
REF DART SPEC M6061T6B
D4422-3: 6061-T6/T62 ALUMINUM SHEET, 0.063 THICK, PER QQ-A-250/11
OR AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027 OR ASTM B209
REF DART SPEC M6061T6S.063

- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
4) UNITS: INCHES UNLESS OTHERWISE NOTED
5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
6) IDENTIFICATION: IDENTIFY WITH DART P/N "D4422-X" AND B/N PER QSI 044 6.1
7) WEIGHT: D4422-1 = 0.01 lbs; D4422-3 = 0.01 lbs

86324

RELEASED
2011-07-06

A	NEW ISSUE	MB	11.06.22
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	11.06.22		

DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWING NO. D4422	REV. A
TITLE SHIM	SCALE NTS
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8 7 6 5 4 3 2 1